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IS 9291 (1979): Dimensions of internal grinding wheels [PGD 9: Abrasives]

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Indian Standard

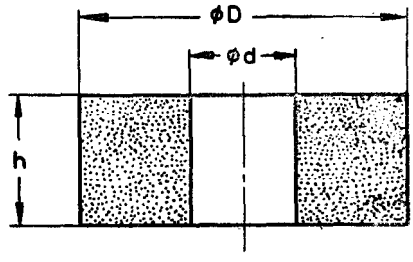
(Reaffirmed 2005)

DIMENSIONS OF INTERNAL GRINDING WHEELS

1. Scope — Covers the dimensions of Type 1 and Type 5 forms of internal grinding wheels.

2. Dimensions

2.1 *For Type 1, Plain Internal Grinding Wheels*



All dimensions in millimetres.

D	h									d H11
6	6	10	13	—	—	—	—	—	—	3, 3·18, 2·38, 2·5
10	6	10	13	—	—	—	—	—	—	3, 3·18, 4·0
13	6	10	13	16	20	25	—	—	—	3, 3·18, 4·0
16	6	10	13	16	20	25	—	—	—	6, 6·35
20	6	10	13	16	20	25	—	—	—	6, 6·35
23	6	10	13	16	20	25	—	—	—	6·35
25	6	10	13	16	20	25	32	—	—	6, 6·35, 9·53, 10
32	6	10	13	16	20	25	32	40	—	9·53, 10
40	6	10	13	16	20	25	32	40	50	9·53, 10, 12·7, 13
45	6	10	13	16	20	25	32	40	50	12·7, 13
50	6	10	13	16	20	25	32	40	—	12·7, 13, 15·88, 16
63	—	—	13	—	20	25	—	40	—	15·88, 12·7, 13, 16, 19·05, 20
80	—	—	13	—	20	25	32	40	50	15·88, 16, 19·05, 20
90	—	—	13	—	20	25	—	40	—	22·23
100	—	—	13	—	20	25	—	40	50	22·23

Note — The underlined dimensions are according to those given in ISO 1117-1975 (*see also* Explanatory Note).

Adopted 30 October 1979

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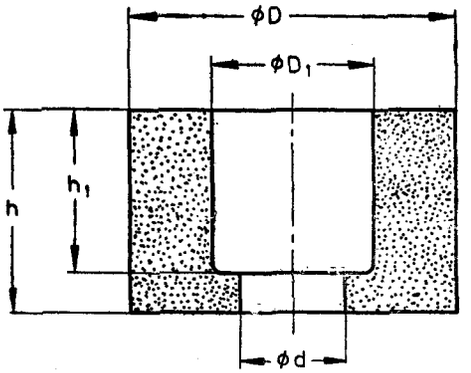
Abrasive Sectional Committee, EDC 13 ; Grinding Wheels Subcommittee, EDC 31 : 1 [Ref : Doc : EDC 13 (2976)]

2.2 *For Type 5, Single Recess Internal Grinding Wheels*



All dimensions in millimetres.

D	h	d H11	D_1	h_1
16	16	6	10	8
	20	6		8
	20	6·35		6
	25	6		6
20	20	6	13	10
	20	6·35		10
	20	6·35		6
25	25	9·53	16	6
	25	10		12
	40	10		8
	40	9·53		16
32	25	10	16	10
	32	9.35		12
	32	9·53		10
40	25	12	20	16
	25	12·7		20
	32	12·7		20
	40	12·7		10
	40	12·7		16
	40	12·7		20
	40	13		10
50	25	15·88	25	16
	50	15·88		25
	50	16		25
63	40	16	25	10
	50	15·88		25
	50	16		25
	63	16		25
80	25	15·88	40	10
	40	15·88		20
	50	15·88		25
90	25	22·23	40	10
	40	22·23		20
	50	22·23		25
100	25	22·23	40	10
	40	22·23		20
	50	22·23		25

Note—The underlined dimensions are according to those given in ISO 1117–1975 (*See also* Explanatory Note).

EXPLANATORY NOTE

The underlined sizes in this standard are according to those given in ISO 1117-1975. The additional sizes have been arrived at on the basis of the demand by large users and only such sizes that are in significant demand have been included. More additional sizes can be obtained from the manufacturers subject to agreement between the purchaser and the supplier. It is recommended that machine tools being manufactured in the country be designed, as far as possible, to adopt the underlined dimensions of grinding wheels specified in the standard. The range has been extended up to 100 mm in accordance with ANSI standard.

In the preparation of this standard, considerable assistance has been derived from following publications:

ISO 1117-1975 Bonded abrasive products — Grinding wheel dimensions (Part 2). International Organization for Standardization.

USAS B 74.2-1974 Specification for shapes and sizes of grinding wheels, and for shapes, sizes and identification of mounted wheels. American National Standards Institute.

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